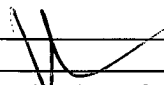
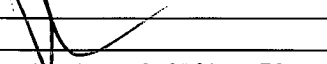


Date: Tuesday, 02/10/2007 12:57:54 PM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ARM
<b>Job Number</b> : 34966	
<b>Estimate Number</b> : 12883	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D3560043
<b>This Issue</b> : 02/10/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3560 UNDER REVIEW
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 34476	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 09/10/2007 <b>Qty:</b> 5 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est Rev:A New Issue 07.05.24 EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



**Comment:** LARGE FABRICATION RESOURCE 1  
PULL FROM STK:

2.0	D3560043	ARM WELDMENT
-----	----------	--------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
ARM WELDMENT **B 32646**

3.0	D35921	PLATE
-----	--------	-------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
PLATE **B 32661 = 4 B 34260 = 1**

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



**Comment:** LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------

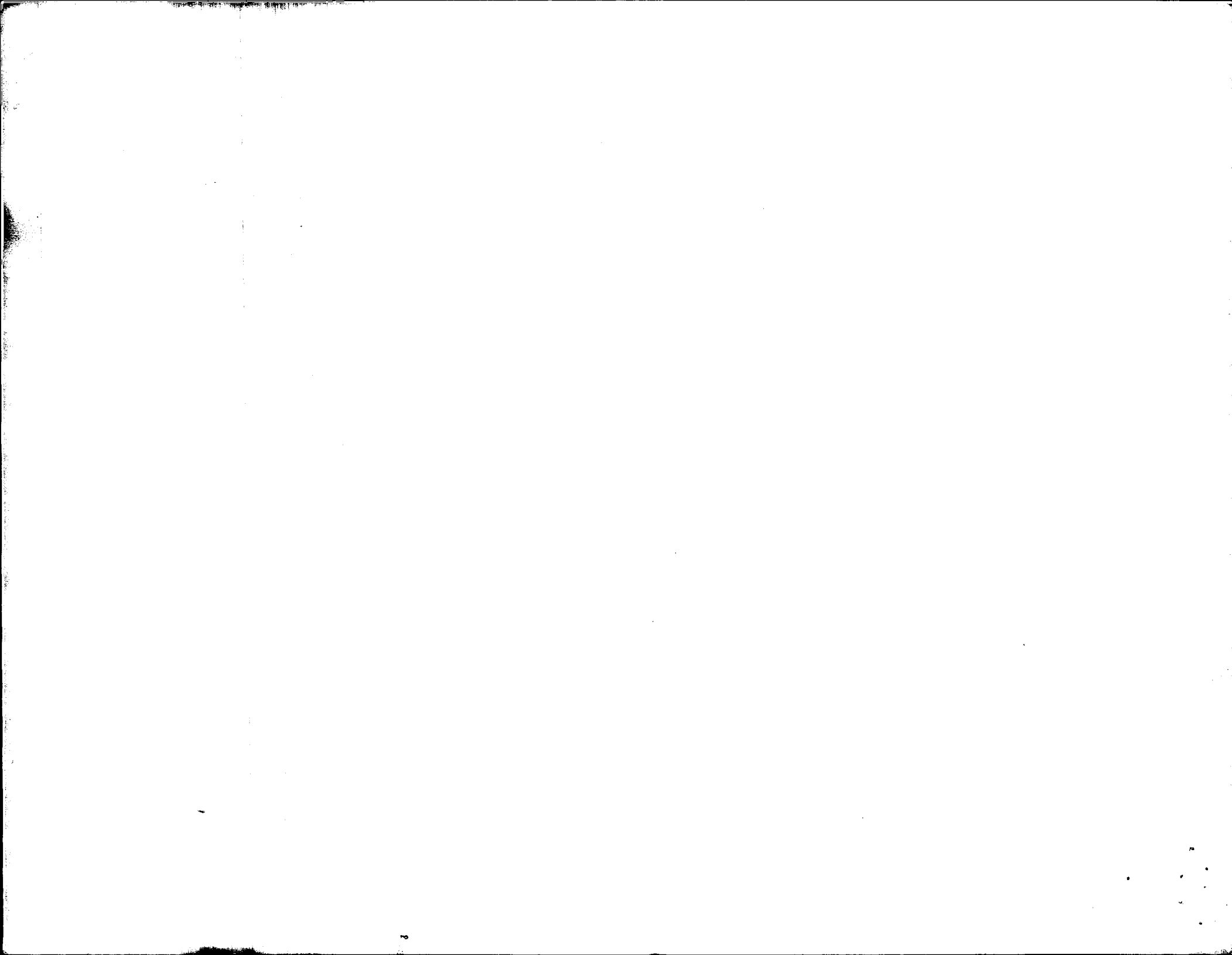


**Comment:** INSPECT WORK TO CURRENT STEP

6.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



**Comment:** VISUAL WELDING INSPECTION



Date: Tuesday, 02/10/2007 12:57:54 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34966

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*A.M.*

*07.10.03*

*(5)*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*R*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*07.10.03*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA*

*A.M.*

*07.10.03*

*(5)*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07.10.03*

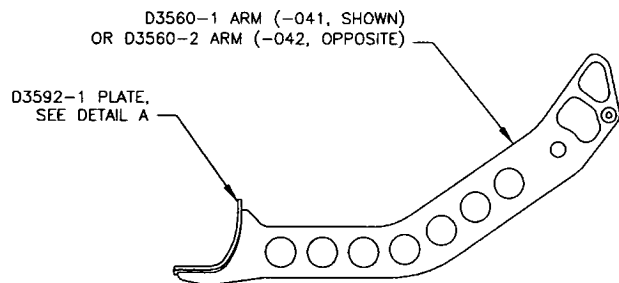
Job Completion



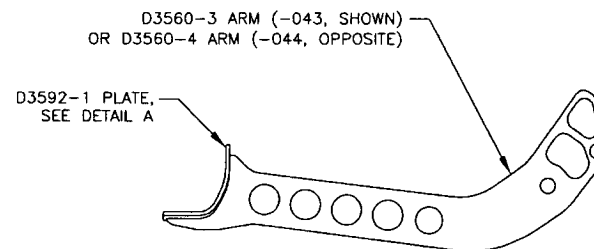
*07.10.03*

*→*

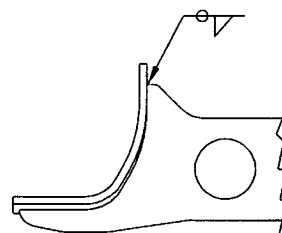
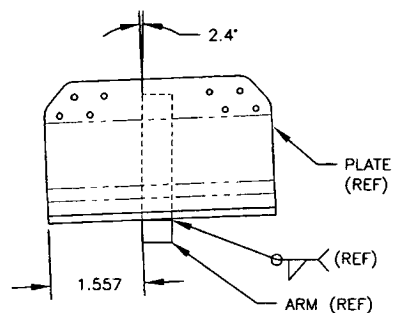




D3560-041 ARM WELDMENT (SHOWN),  
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),  
D3560-044 ARM WELDMENT (OPPOSITE)



**DETAIL A**  
(SCALE 1:1)

**GENERAL NOTES**

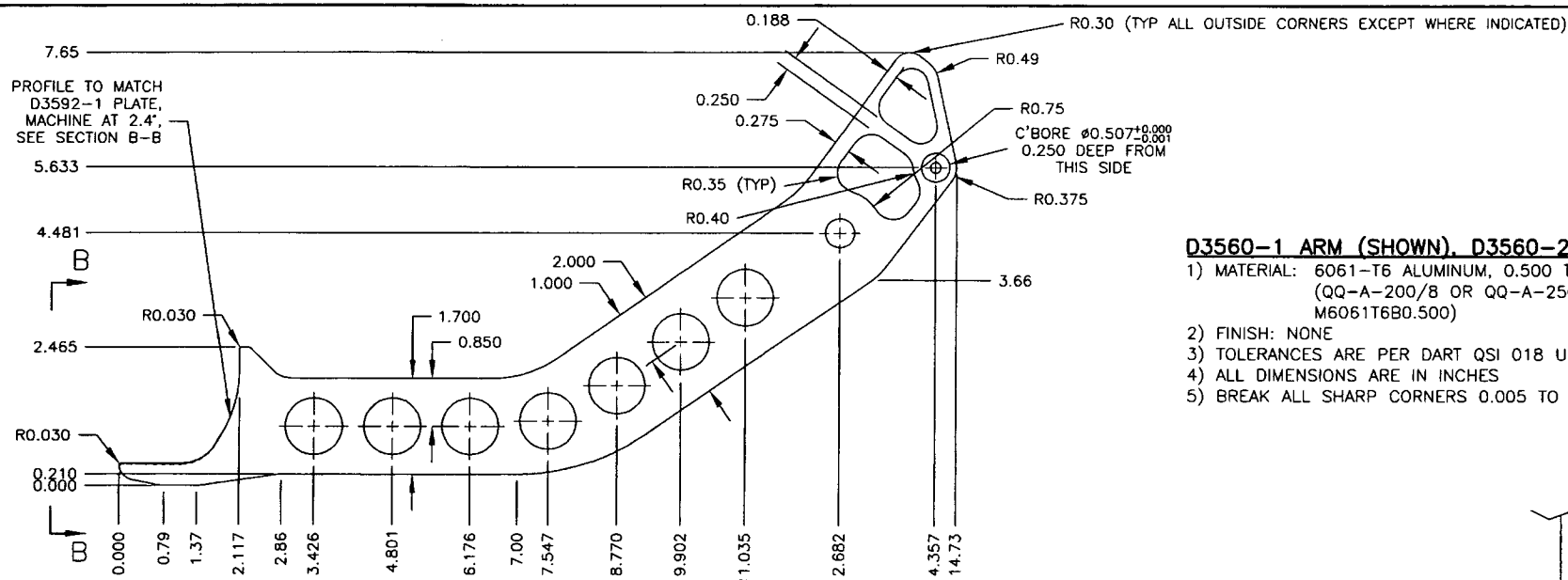
- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
07.06.19

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

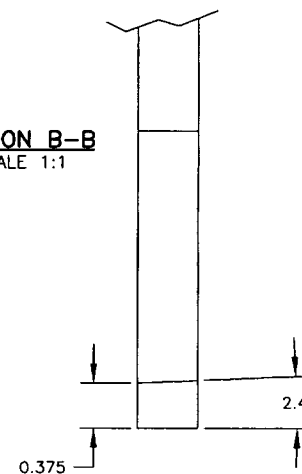
C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3560
DATE	07.06.19	TITLE ARM WELDMENT
		REV. C SHEET 1 OF 3 SCALE 1:4



### D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

### SECTION B-B SCALE 1:1

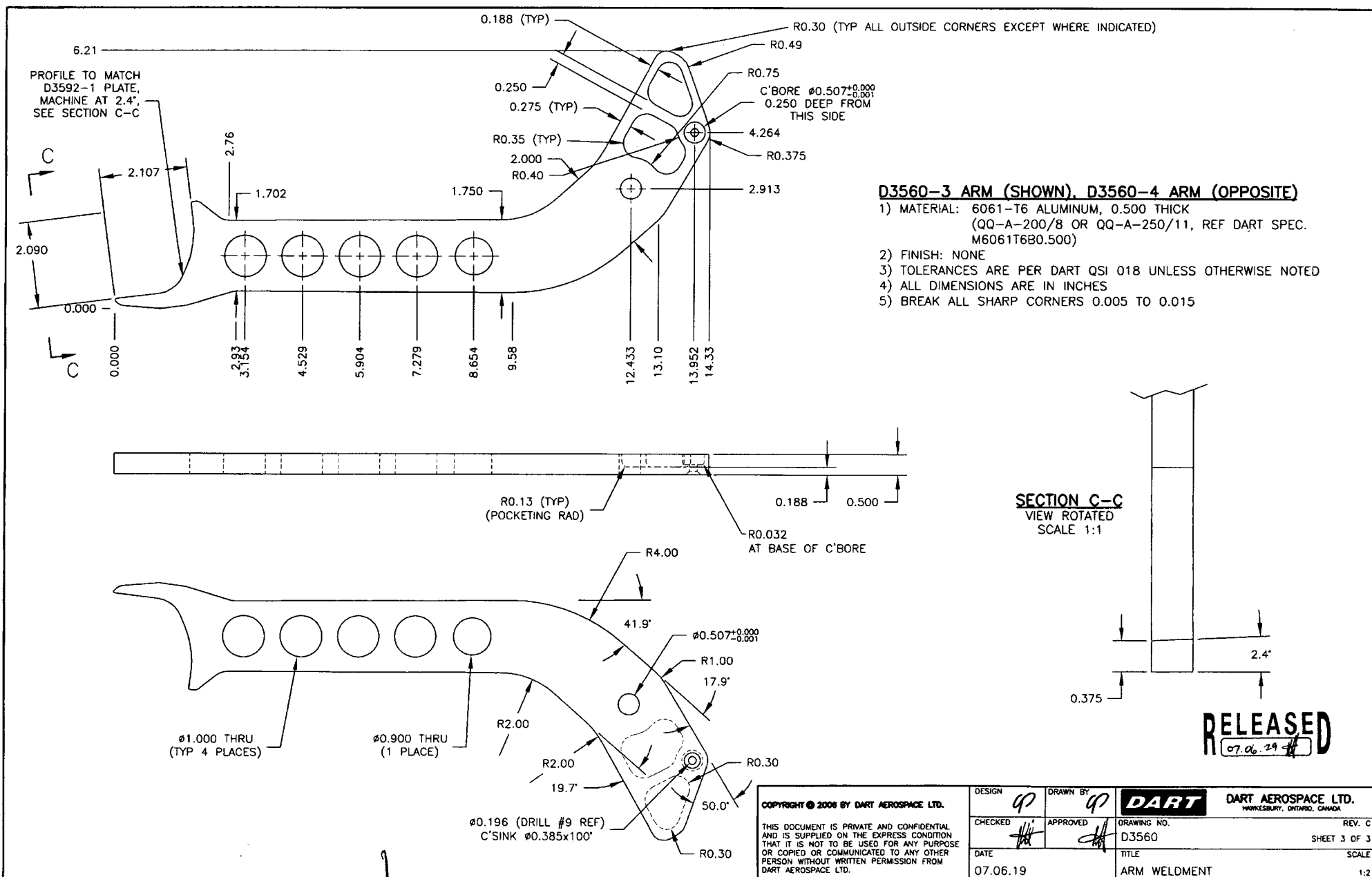


**RELEASED**  
07.06.29-#

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN	qf	DRAWN BY	qf	<b>DART</b>	DART AEROSPACE LTD. MARKESBURY, ONTARIO, CANADA
CHECKED	qf	APPROVED	qf	DRAWING NO. D3560	REV. C SHEET 2 OF 3
DATE	07.06.19	TITLE	ARM WELDMENT	SCALE	1:2







W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 07/10/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.03	4.	Qty(1) ARM IS TOO NARROW AT WELD BECAUSE OF GRINDING DURING RE-WELD	UP 07.10.03 per QSI 042	SCRAP. AND Replnee  <del>Re-weld as per</del> D3560-43 B2 32644 D3560-43 B2 32644 As per QSI 004	PH 07.10.03  PH 07.10.03  PH 07.10.03	En H10/03	UP 07.10.03 per QSI 042	En H10/03
				Inspect head & welding inspection	PH 07.10.03	En H10/03	↓	En H10/03

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/04	to	(3) Scrap all the parts that were reviewed twice. (Arm D 32646) - <del>Drum</del> . and <del>chairs</del>	UP 07.10.04 per QSI 042	Scrap and Destroy. Replace with all new parts. weld per ASZ 004	pk 07.10.04	07/10/04	UP 07.10.04 per QSI 042	En 07/10/04
			UP 07.10.04 per QSI 142	Re-inspect weld AC 19 Re inspect ac 15	PD 07.10.04 En 07/10/04	07/10/04	UP 07.10.04 per QSI 042	En 07/10/04

NOTE: Date & initial all entries